

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026175**Date Inspected:** 31-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Components				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Vessel Zhenghua #19

This QA Inspector also randomly observed the following on the Vessel Zhenghua #19:

ZPMC workers were observed performing what appeared to be initial tightening of ASTM A325M bolt sets using a pneumatic impact wrench at OBG Segment 13BE, south (bikepath) side, bottom plate stiffeners, splice plates with stiffeners, panel points 121~121.5; and OBG Segments 13AE/13BE transverse joint, south (bikepath) side, edge plate stiffeners, splice plates, panel points 120~120.5. The bolt sets and adjacent steel being bolted showed no turn-of-nut initial tightening markings. ZPMC Bolting Foreman Ruo informed this QA Inspector that the the operation was intitial tightening only and the above noted marks would be applied before ABF Personnel checked the initial tightening had been completed and before final tightening occured.

ZPMC workers were observed placing ASTM A325M bolt sets in OBG Segments 13AE/13BE transverse joint, north (crossbeam) side, edge beam splice plates, panel points 120~120.5.

ZPMC workers were observed performing what appeared to be final tightening of ASTM A325M bolt sets using a pneumatic impact wrench at OBG Segment 13CE, longitudinal diaphragm, outer side, corner splice plates, south (bikepath) side, panel point 123; and OBG Segment 13BW, north (crossbeam) side, side plate stiffener splice plates, panel points 121~121.5. The bolt sets and adjacent steel being bolted showed turn-of-nut initial tightening

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markings.

ZPMC workers were observed performing what appeared to be initial tightening of ASTM A325M bolt sets using a pneumatic impact wrench at OBG Segment 13BW, north (counterweight) side, bottom plate stiffeners, splice plates with stiffeners, panel points 121~121.5; and OBG Segments 13AW/13BW transverse joint, south (crossbeam) side, side plate stiffener splice plates, panel points 120~120.5. The bolt sets and adjacent steel being bolted showed no turn-of-nut initial tightening markings.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
